

Work Order ID 119682

\*119682\*

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May-15-14 3:37:49 PM

Item ID: D3646-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Arm

Stop

\*NS2\*

Start Date: 5/15/14

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-05-23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3646	Rev C								

100

0.00

\*100\*

NC BRAKE

Brake NC

Memo

0.00

10

FF 14-07-17

Brake NC

1-Punch to length as per Dwg D3646 & template DT8958

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

10

FF 14-07-17

Small Fab

1-Deburr

DAS

27

9-89

120

0.00

\*120\*

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

MHJ17

10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b>	<b>General</b>														
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced										
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up										
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure										
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld										
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled										
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other										
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge											
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread												
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set												
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration												
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence												

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Page 2

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Start

\*NS1\*

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Stop

\*NS2\*

Item Name: Arm

Start Date: 5/15/14

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Black Sandtex(Ref:4.3,5.7) per QS1005 4.3

0.00

\*130\*

Powdercoat

Powder Coating

1137892

Memo

0.00

L20  
20  
1:50

10 14-7-20 CN

140

QC3- Inspect Part Finish

0.00

SMF  
MHG)

10 \_\_\_\_\_

\*140\*

QC

Quality Control

Memo

0.00

150

Identify as per dwg & Stock Location: ST360

0.00

ST360

10 14-7-21

\*150\*

Packaging

Packaging

Memo

0.00

DAS  
26  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: Part No. NCR No.	DISPOSITION			AGAINST DEPARTMENT/PROCESS														
	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Crosstube	Small Fab	Finishing	Composite	Water Jet	Prod. Eng. Coor.	Rec/Store/Packaging	Supplier	Engineering	Quality	Other
	Suspected	Unapproved																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General											
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced								
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up								
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure								
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld								
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled								
Crushing	Countersink	Misaligned/off center	Positioned Wrong									
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge									
Inspection Strip in Tube	Drawing	Misread										
Marks/Chatter	Drill Holes	Off-set										
Turning Sequence	Finish	Out of Calibration										
Wave/Twist in Tube	Fit/Function	Out of Sequence										

# DART AEROSPACE LTD



Description: ARM

**Work Order:** 119682

Inspection Drawing: D 3646.

Rev: C

Part Number: D3646-1

## **INSPECTION SHEET**

Measured by:	Checked By:	QC inspector:	Engineering Approval (if necessary)
FF Date 14-07-17	30 9-89 Date 14/07/17	EJ SAS Date 14/07/17	Date